

Date: Tuesday, 7/18/2006 3:00:35 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 A/B HIGH GEAR WEB
 Job Number : 27964
 Estimate Number : 10455
 P.O. Number : N/A Part Number : D26543
 This Issue : 7/18/2006 S.O. No. : N/A Drawing Number : D2654 REV E1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : E1
 Previous Run : 26865 Material : N/A
 Due Date : 7/30/2006 Qty: 4 Um: Each
 Written By : *See Comment Below*
 Checked & Approved By : *OK 06-07-19*
 Comment : Est Rev: D 99.02.04 Fixed typo, Changed procedure DM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26005108 Extrusion 'I Beam' thin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2600-5 Web

B24410

PM 06-07-20 (4)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654

PM 06-07-20 (4)

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654

PM 06-07-21 (4)

3-Using the uni-bit, open holes to finish size as per Dwg D2654

PM 06-07-21 (4)

4-Deburr holes and ends

PM 06-07-21 (4)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-07-21 (4)

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PM 06-07-21 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA: SP Date: 06/07/25
 QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/18/2006 3:00:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 27964

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a-m

06-07-20

(24)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

pmc 06-07-21 (24)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.21

Job Completion



U 06.07.21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

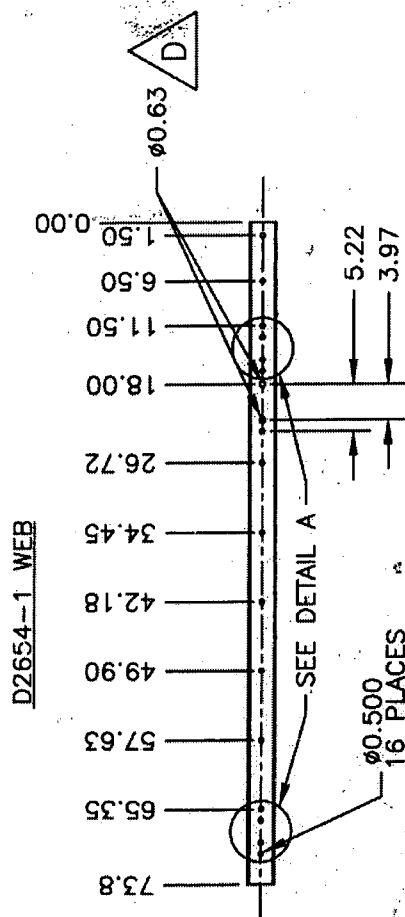
NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

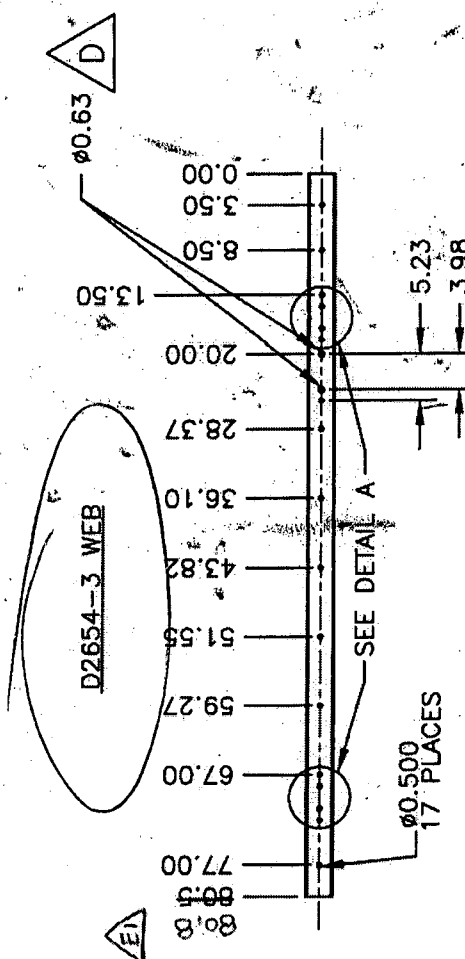
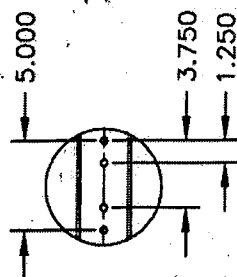


DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE USA, INC.
CHECKED	<i>#</i>	APPROVED	<i>#</i>	PORT HADLOCK, WA
DATE	04.05.26	DRAWING NO.	D2654	REV. E
				SHEET 1 OF 2
		TITLE	WEB	SCALE
				1:20
A	97.03.25	NEW ISSUE		
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29	CHANGED HOLE PATTERN		
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$		
E	04.05.26	CHANGE LENGTHS, REFORMAT		
E1	<i>CP</i> 04.08.04	PER TOOLING; 80.8 WAS 80.5		

RELEASED
04.06.22



DETAIL A
SCALE 1:10



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27964

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1997 by DART AEROSPACE USA, INC.

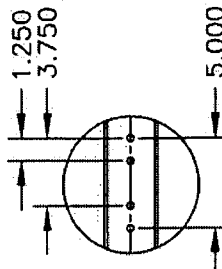
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



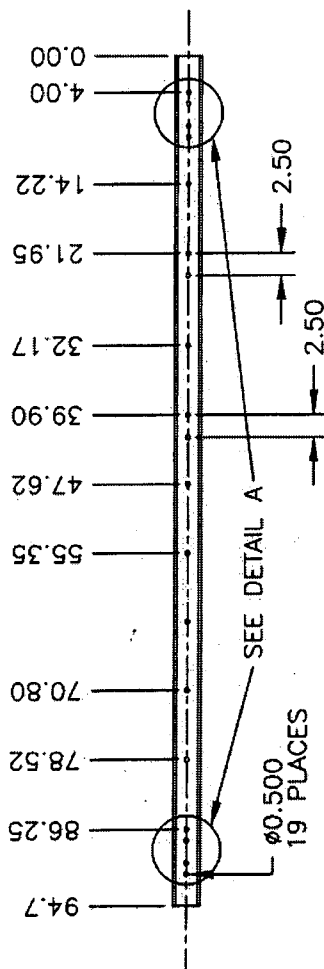
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

RELEASED
04.06.22

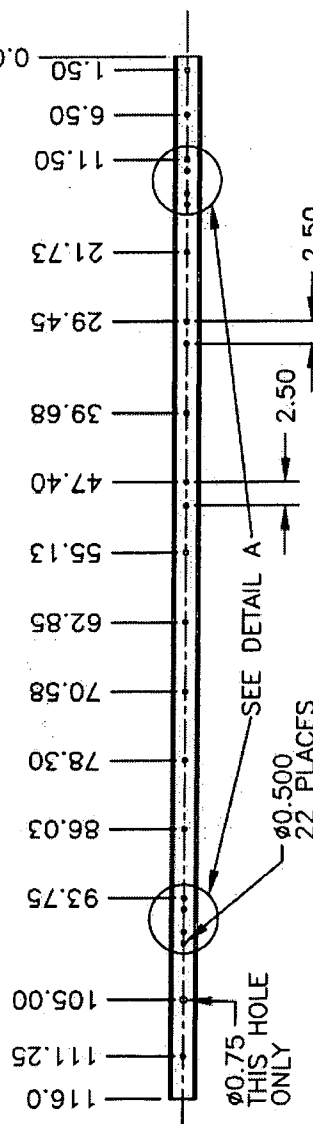
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27964

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

